

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009199**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

SMAW repair welding of weld joint WD1-SA183-28M-4 located on west tower. Welder was identified as 040656.

ZPMC QC was identified as CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding variables recorded by QC1 and QC1's assistants appeared to comply with WPS-485-SMAW-2G(2F)-repair.

SMAW repair welding of weld joint WD1-SA183-28M-2 located on west tower. Welder was identified as 040733.

ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding variables recorded by QC1 and QC1's assistants appeared to comply with WPS-485-SMAW-2G(2F)-repair.

SMAW welding of weld joint WD1-A6003-7-60 located on west tower. Welder was identified as 040668. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding

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variables recorded by QC1 and QC1's assistants appeared to comply with WPS-B-T-4113-1.

SMAW welding of weld joint WD1-A6003-7-58 located on west tower. Welder was identified as 040614. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding variables recorded by QC1 and QC1's assistants appeared to comply with WPS-B-T-4113-1.

SMAW welding of weld joint WD1-A6003-7-60 located on west tower. Welder was identified as 041271. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding variables recorded by QC1 and QC1's assistants appeared to comply with WPS-B-T-4113-1.

SMAW tack welding of weld joint ESD1-A67-1 16 located on east tower. Welder was identified as 206362. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC Inspectors Yuan Wen Jie and Xu Jing Long, who were not CWI's. The welding variables recorded by QC1 and QC1's assistants appeared to comply with WPS-B-T-2112.

### Bay 10

This QA inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint SSTL4-1B/L-14, 15 located inside south tower shaft, lift 4, skin B. Welders were identified respectively as 052075, 057180. ZPMC QC was identified as CWI Li Ming (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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